

Work Order ID 54349

December 8, 2009 9:26:45 AM



Page 1

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 08/12/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 15/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

09-12-8

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3584

Rev A

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to Length as per Dwg D3584 2-Drill Pilot Holes using DT8960 Drill
Jig 3-Open pilots to 1.000" as per Dwg D3584 4-Deburr

2 11/12/8

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

9-12-8 (2)

120

0.00



Chemical Conversion Coat per QS1005 4.1

HandFinish

Memo

0.00

Hand Finishing

2 11 9/12/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54349

December 8, 2009 9:26:45 AM



Page 2

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 08/12/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 15/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

DD

9-12-8

2

140 Identify as per dwg & Stock Location: LG

0.00



Packaging Memo

0.00

Packaging

2 11/9/12/8

150 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

09/12/08

ME 09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 9:26:52 AM

Page 1

Work Order ID: 54349



Parent Item: D3584-1



Parent Item Name: Web

Start Date: 08/12/2009

Required Date: 15/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2963-125

Manufactured

No

110

Each

148.0000

2.0000



105 I Beam Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

148

27775

8

28673

140

②

12/12/08

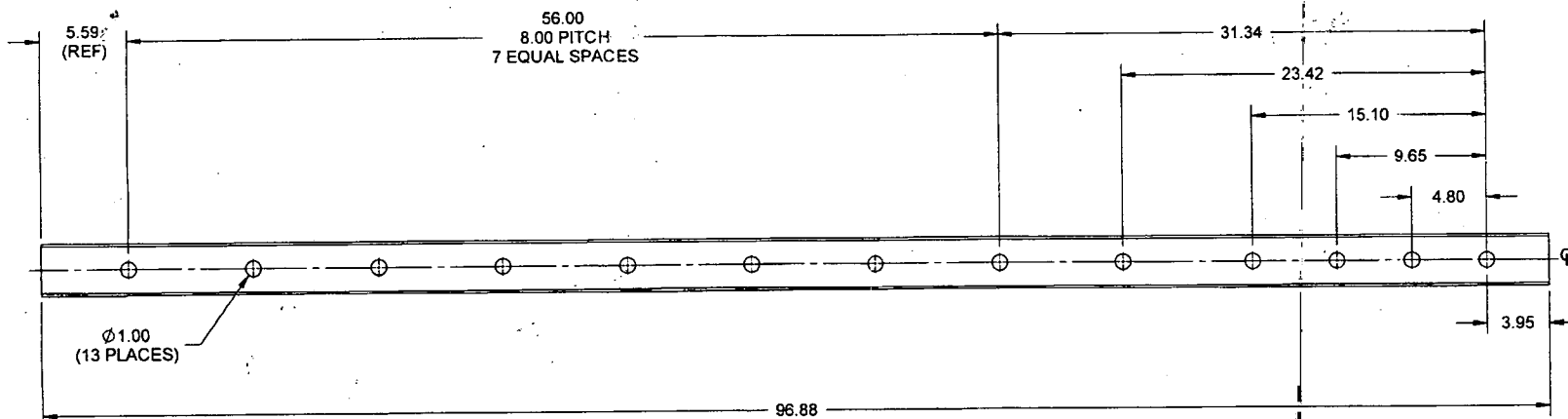
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3584-1 WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 54349
11 0912-1

RELEASED
07-11-22/10

NOTES:

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.08 lbs

A	NEW ISSUE	PH	07.06.08
REV. I	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO. D3584	REV. A
MFG. APPR.	PH	TITLE	SHEET 1 OF 1
APPROVED	PH	WEB	SCALE 1:8
DE APPR.	PH	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
DATE	07.06.08	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries